

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026559**Date Inspected:** 24-Oct-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** As noted below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Douglas Frey was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

1. 7E PP57 Pipe Welding (Exterior)
2. 12W 13W Side Plate "E" (Exterior)
3. 12W 13W Edge Plate "F" (Interior)
4. 7E PP59 Pipe Welding (Exterior)
5. 12E 13E Edge Plate "F" (Interior)
6. 13E 14E "A" Deck Seal Passes (Exterior)
7. 13E 14E "A2" Deck Seal Passes (Exterior)
8. 13E 14E "A3" Deck Seal Passes (Exterior)

1. 7W PP57 Pipe Welding (Exterior)

The QA inspector observed F.W. Spencer welder Curtis Jump ID# 7326 performing Shielded Metal Arc Welding (SMAW) in the 2G horizontal position on 4" domestic water pipe and 2.5" compressed air pipe located at 7E PP57 weld #7/2.5/57/NE and weld #7/4/57/NE. The QA inspector verified the fit up of the joints and found it to be satisfactory. The QA inspector observed the QC inspector identified as Steve Jensen- monitoring the welding to ensure the welding parameters were in compliance pertaining to WPS-1-12-1 Revision 2 (1.12). The welder was observed implementing 6010 electrodes in the root pass with the balance using 7018 electrodes. The

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## WELDING INSPECTION REPORT

( Continued Page 2 of 4 )

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QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work appears to be in general conformance with the contract documents.

### 2. 12W 13W Side Plate "E" (Exterior)

The QA inspector observed ABF welder Rory Hogan ID#3186 utilizing Plasma Arc Cutting to remove sections of the backing bar on the exterior of the OBG at Side Plate "E". The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work is in progress and appeared to be in general conformance to the contract requirements.

### 3. 12W 13W Edge Plate "F" (Interior)

The QA inspector randomly observed ABF welding operator Jorge Lopez ID#6149 performing Flux Core Arc Welding with Gas (FCAW-G) in the 3G position on edge plate "F" at 12W 13W of the OBG. The QA inspector observed the QC inspector identified as John Pagliero monitoring the welding to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-3110-3. The parameters were noted as (A/250/V22). The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work is in progress and appears to be in general conformance to the contract requirements.

### 4. 7E PP59 Pipe Welding (Exterior)

The QA inspector observed F.W. Spencer welder Curtis Jump ID# 7326 performing Shielded Metal Arc Welding (SMAW) in the 2G horizontal position on 4" domestic water pipe and 2.5" compressed air pipe located at 7E PP59 weld #8/2.5/59/NE and weld #8/4/59/NE. The QA inspector verified the fit up of the joints and found it to be satisfactory. The QA inspector observed the QC inspector identified as Steve Jensen monitoring the welding to ensure the welding parameters were in compliance pertaining to WPS-1-12-1 Revision 2 (1.12). The welder was observed implementing 6010 electrodes in the root pass with the balance using 7018 electrodes. The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work appears to be in general conformance with the contract documents.

### 5. 12E 13E Edge Plate "F" (Interior)

The QA inspector randomly observed ABF welding operator Fred Kaddu ID#2188 performing Shielded Metal Arc Welding (SMAW) in the 3G position on edge plate "F" at 12E 13E of the OBG. The QA inspector observed the QC inspector identified as Jesse Cayabyab monitoring the welding to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1110A Revision 1. The parameters were noted as (A/135). The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work is in progress and appears to be in general conformance to the contract requirements.

### 6. 13E 14E "A5" Deck Seal Passes (Exterior)

The QA Inspector randomly observed ABF welder Wai Kit Lai ID#2953 perform FCAW-G in the 1G Flat position on A5 of 13E 14E on the exterior of the OBG. The QA inspector observed the QC inspector identified as

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## WELDING INSPECTION REPORT

( Continued Page 3 of 4 )

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John Pagliero monitoring the welding to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-F3200-2. The parameters were noted as (A/270/V/24/TS/440/HI/0.88). The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work is in progress and appears to be in general conformance to the contract requirements.

### 7. 13E 14E "A2" Deck Seal Passes (Exterior)

The QA Inspector randomly observed ABF welder Xiao Jian Wan ID#9677 perform FCAW-G in the 1G Flat position on A2 of 13E 14E on the exterior of the OBG. The QA inspector observed the QC inspector identified as John Pagliero monitoring the welding to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-F3200-2. The parameters were noted as (A/252/V/23/TS/520/HI/0.67). The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work is in progress and appears to be in general conformance to the contract requirements.

### 8. 13E 14E "A3" Deck Seal Passes (Exterior)

The QA Inspector randomly observed ABF welder Richard Garcia ID#5892 perform FCAW-G in the 1G Flat position on A3 of 13E 14E on the exterior of the OBG. The QA inspector observed the QC inspector identified as John Pagliero monitoring the welding to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-F3200-2. The parameters were noted as (A/240/V/23/TS/400/HI/0.82). The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work is in progress and appears to be in general conformance to the contract requirements.

Note: The QAI reviewed the observations and inspection with QA Lead Inspector, Daniel Reyes, written in this report. No issues were noted by the QAI and the QA Lead Inspector concurs with the QA report.

### Summary of Conversations:

At the beginning the shift the QA inspector met with QC inspector William Sherwood and discussed the welders assignments and locations for the shift to include pending issues, ongoing work and required testing.

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## WELDING INSPECTION REPORT

( Continued Page 4 of 4 )

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### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910 , who represents the Office of Structural Materials for your project.

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**Inspected By:** Frey,Doug

Quality Assurance Inspector

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**Reviewed By:** Levell,Bill

QA Reviewer